

ASAP

Dart Aerospace Ltd.

Date: Thursday, 19/03/2009 2:23:11 PM
User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SUPPORT ANGLE
Job Number :	46604		
Estimate Number :	13281		
P.O. Number :		Part Number :	D36981
This Issue :	19/03/2009	S.O. No. :	
Prsh't Rev. :	NC	Drawing Number :	D3698 REVC
First Issue :	//	Project Number :	N/A
Previous Run :	41656	Drawing Revision :	C
	Type :	Material :	
	SMALL /MED FAB	Due Date :	23/03/2009
Written By :		Qty:	10
Checked & Approved By :		Um:	Each
Comment :	Est Rev:A 08-04-25 new issue DD verified by:EC Est Rev:B 08-07-14 revB as per dwg DD verified by:ec Est rev:C 08-10-07 revC as per dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S032	6061-T6 Sheet 0.032"
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Comment: Qty.: 0.4700 sf(s)/Unit Total : 4.6998 sf(s)
 6061T6 aluminium sheet .032" thick
 (M6061T6S032)
 Batch: 111063 **IB 9-3-22**

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3698
 Dwg Rev: C **IB 9-3-22**
 Prog Rev: C
 ****grain direction along 1.378" ****
 2- Deburr if necessary **IB 9-3-22**

(11)

(P12) →

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 9-3-22

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

8 09/03/23 (x10)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

FF 09/03/25 (8)


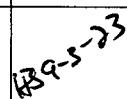

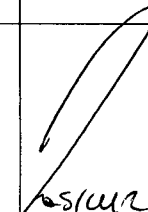


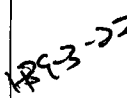

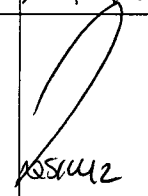



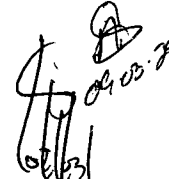
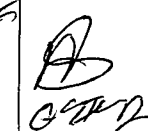
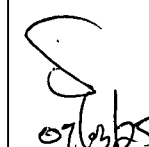
1-Bend 105 deg. angle as per Dwg D3698

SB 09/03/23 (8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3698-1 PAR #: NA Fault Category: Prod / Mfg. Pass' med & small NCR: (Yes) No DQA: D Date: 09/04/03
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/04/03

NCR: <u>46604</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/3/23	20	During inspection found one part with cut out from water jet in center of part. R.C. Machine Mpl Function		Scrap & no replace	 09-3-23	 09/03/23		 02/03/23
9/3/23	20	found two (qty x2) parts with uneven cuts along outer edge R.C. Machine Mpl Function		Buff edge smooth	 09-3-22	 09/03/23		 09/03/23
				one edge is not straight enough Scrap and destroy qty 1	 09/03/25	 09/03/25		 09/03/25

NOTE: Date & initial all entries

Date: Thursday, 19/03/2009 2:23:11 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ANGLE

Job Number: 46604

Part Number: D36981

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-form curve as per dwg D3698 and verify using template DT9001

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sc 09/03/25 (X8)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 09/03/30 (8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-30 (9)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: GA

Sc 09/03/ (9)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/01 (A)

Job Completion



mf 09-03-31

DART AEROSPACE LTD		Work Order: 46604
Description: SUPPORT ANGLE		Part Number: D3698-1
Inspection Dwg: D3698 Rev: C		Page 1 of 1

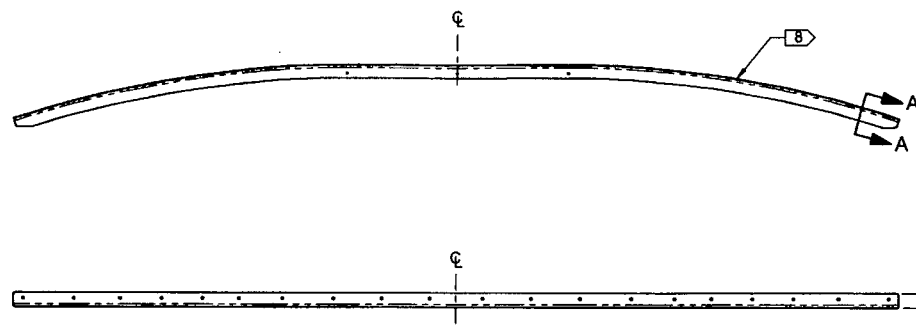
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

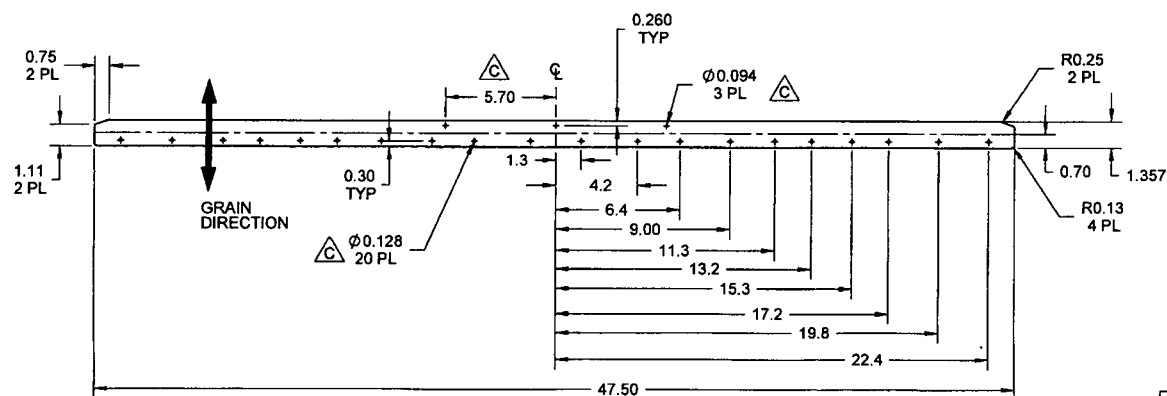
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .094	+ .004 - .001	.096	✓			
Ø .128	+ .005 - .001	.129	*			
1.357	+/- .016	1.365	*			
.30	+/- .030	.300	✓			
.260	+/- .010	.260	✓			
1.3	+/- .100	1.301	✓			
4.2	+/- .100	4.200	✓			
6.4	+/- .100	6.400	✓			
9.00	+/- .030	9.00	✓			
11.3	+/- .100	11.301	✓			
13.2	+/- .100	13.2	✓			
15.3	+/- .100	15.3	✓			
17.2	+/- .100	17.2	✓			
19.8	+/- .100	19.8	✓			
22.4	+/- .100	22.4	✓			
47.50	+/- .030	47.50	✓			
5.70	+/- .030	5.696	✓			
1.11	+/- .030	1.11	✓			
.032	+/- .010	.032	✓			

Measured by: IB	Audited by: S	Prototype Approval: R/H
Date: 9-3-22	Date: 09/03/23	Date: R/H

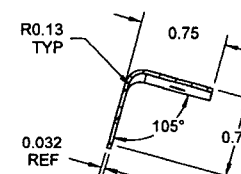
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3698-1 SUPPORT ANGLE
(MAKE FROM D3698-1F FLAT PATTERN)



D3698-1F FLAT PATTERN



SECTION A-A

RELEASED
08-09-08

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.032 THICK
REF. DART SPEC. M6061T6S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.20 lbs
- 8) FORM AS PER TEMPLATE DT9001

C	ZONE B5 Ø0.094 HOLE QTY WAS 29 PL. ZONE B6 ADDED "Ø0.128, 20 PL". ZONE B6 5.70 DIMENSION WAS REF.	AJS	08.09.08
B	REMOVE POWDER COAT. ZONE A,8	RF	08.06.02
A	NEW ISSUE	RF	08.05.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3698	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SUPPORT ANGLE	NTS
DATE	08.09.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	